

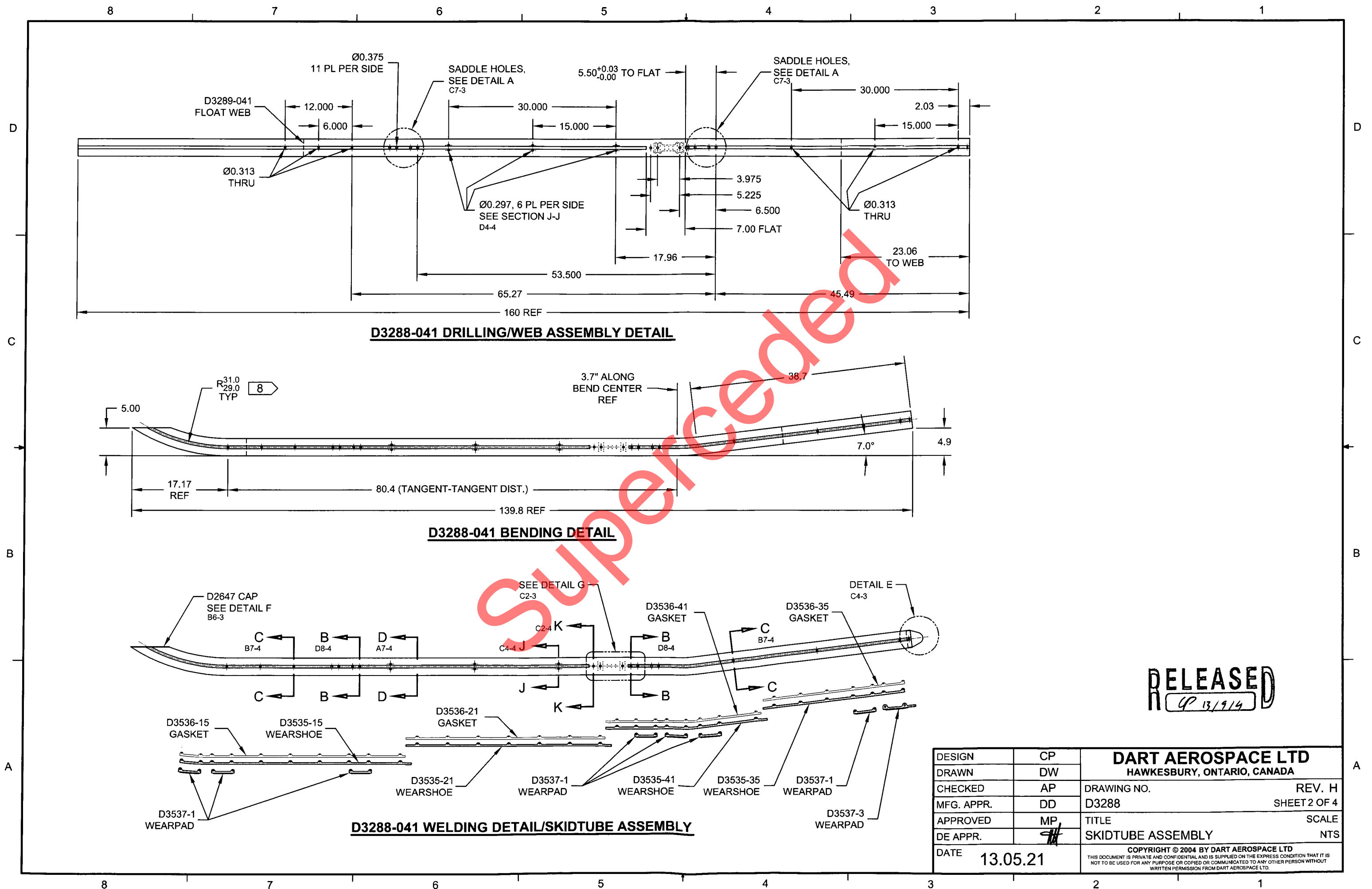
Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
9	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN960C416	WASHER
78	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN3C3A BOLT)
2	NAS1515H3L	WASHER

GENERAL NOTES:

1. MATERIAL: N/A
2. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
3. TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6. IDENTIFICATION: NONE
7. WEIGHT: 20.8 LBS
8. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
9. BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
10. ALL HOLES DRILLED ON CENTERLINES EXCEPT WHERE SHOWN.
11. DRILL Ø0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH.
12. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/-291.
13. WELDING: PER DART QSI 004.
14. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN OFF EXCESS GREASE WITH WASH 'N WIPE DEGREASER

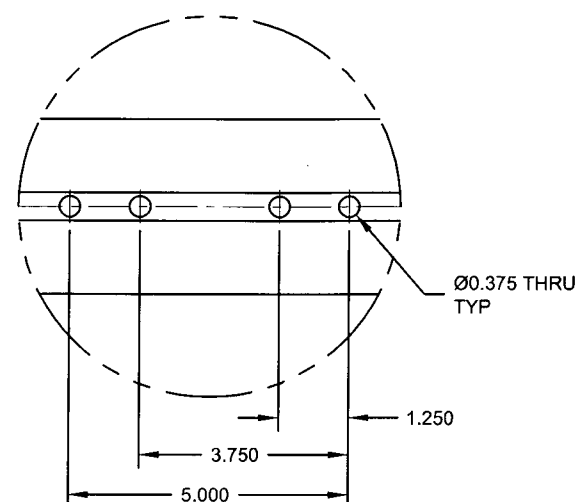
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H	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-256	DW	13.05.21
G	REFORMAT DWG, RMV LPS-3 (ZN B6-3) RMV C'BORE & ADD SECTION K-K (ZN C2-4)	CP	09.06.17
F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALS7-1032-130; IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17° INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.06.04
C	NEW INSERTS, SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	AP	DRAWING NO.	REV. H
MFG. APPR.	DD	D3288	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	13.05.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

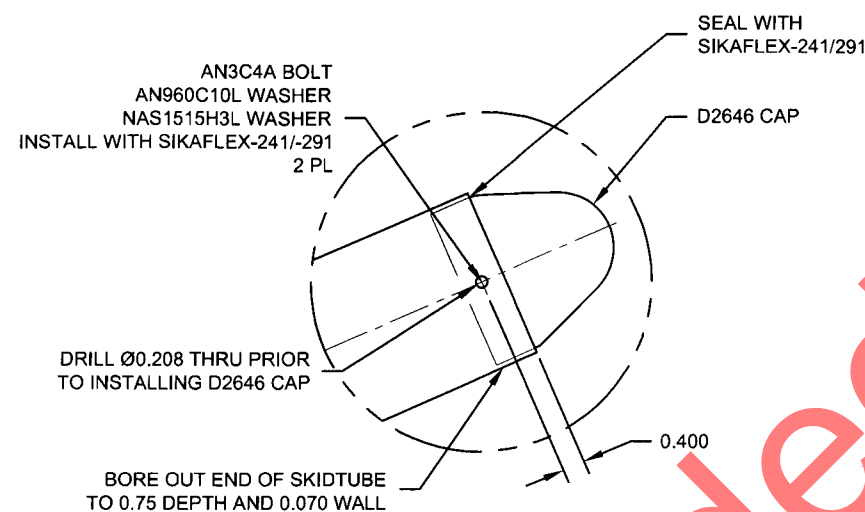


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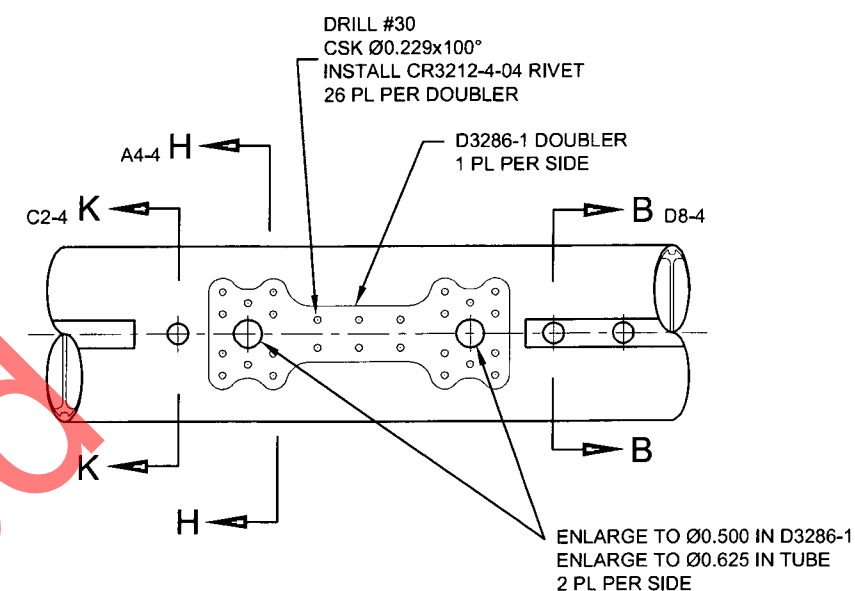
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MFG. APPR.	DD	D3288	SHEET 2 OF 4
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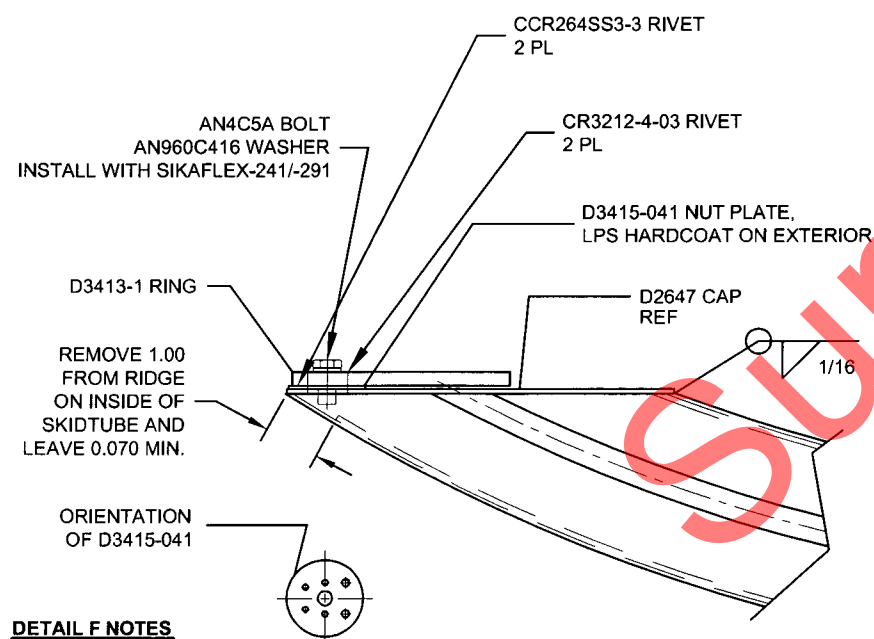
DETAIL A: DRILL DETAIL
SADDLE HOLES, SCALE 5X
D6-2, D4-2



DETAIL E
SCALE 5X
B3-2



DETAIL G
SCALE 5X
B5-2

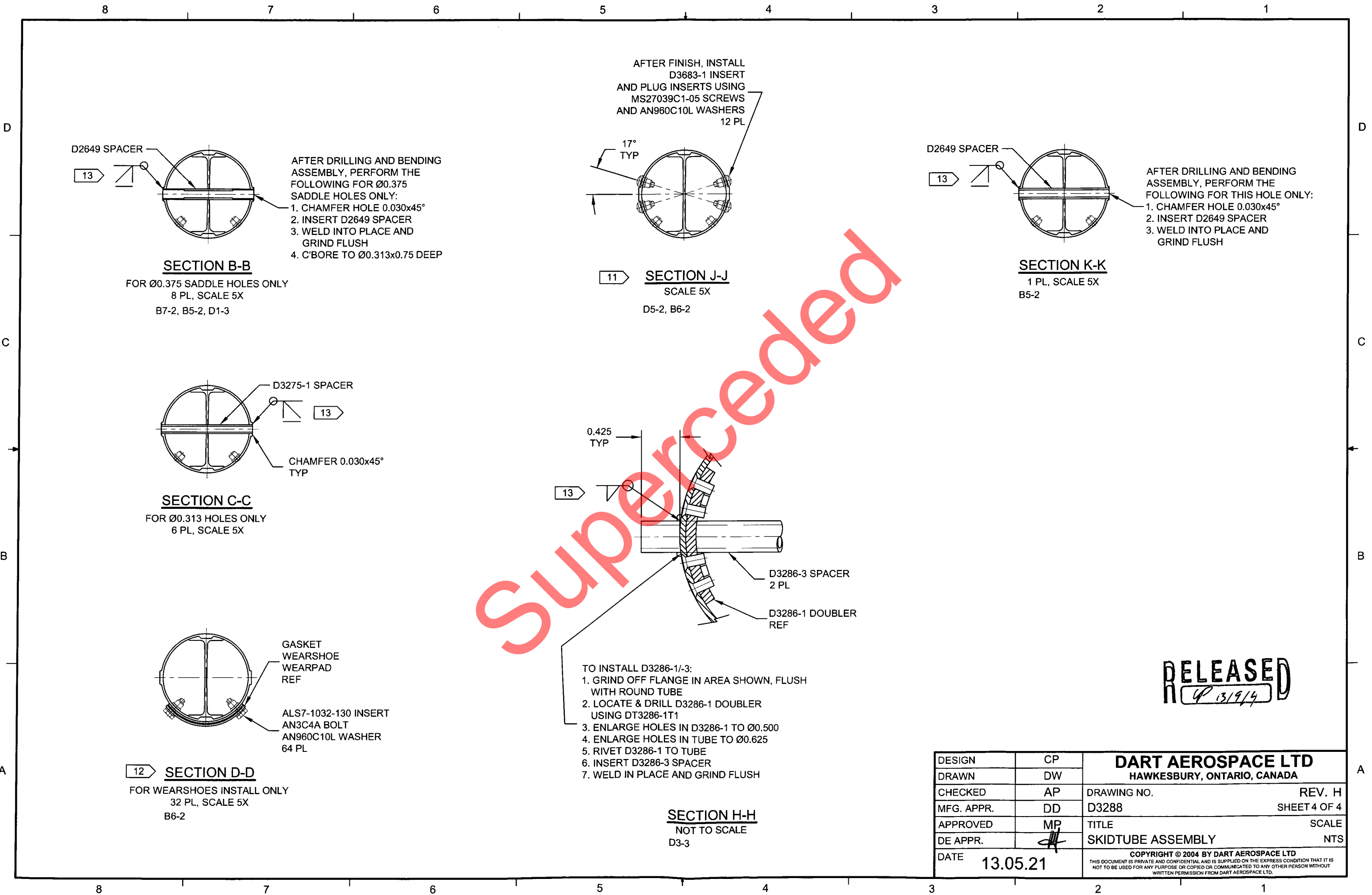


- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

DETAIL F: END FINISHING DETAIL
SCALE 5X
B7-2

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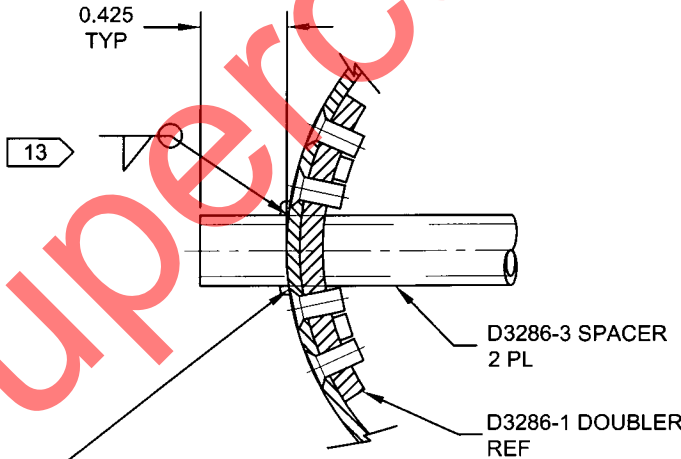
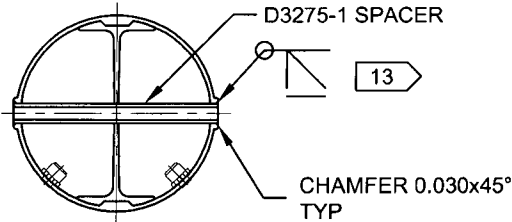
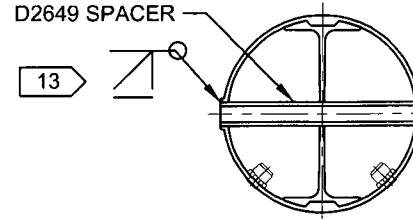
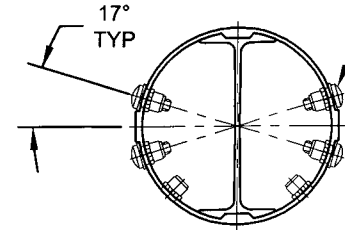
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CHECKED	AP	DRAWING NO.	REV. H
MFG. APPR.	DD	D3288	SHEET 3 OF 4
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AFTER DRILLING AND BENDING
ASSEMBLY, PERFORM THE
FOLLOWING FOR Ø0.375
SADDLE HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND
GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

AFTER FINISH, INSTALL
D3683-1 INSERT
AND PLUG INSERTS USING
MS27039C1-05 SCREWS
AND AN960C10L WASHERS
12 PL

AFTER DRILLING AND BENDING
ASSEMBLY, PERFORM THE
FOLLOWING FOR THIS HOLE ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND
GRIND FLUSH



TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH
WITH ROUND TUBE
2. LOCATE & DRILL D3286-1 DOUBLER
USING DT3286-1T1
3. ENLARGE HOLES IN D3286-1 TO Ø0.500
4. ENLARGE HOLES IN TUBE TO Ø0.625
5. RIVET D3286-1 TO TUBE
6. INSERT D3286-3 SPACER
7. WELD IN PLACE AND GRIND FLUSH

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